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D3859-041
Job Sheet 186885



Part No: D3859-041

Job Qty: 8 ea

Part Name: Wearplate Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/22/18

Job Tracking No:

Due Date: 12/10/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D3859 REV.C IPP Rev:A 09-02-03 new issue DD verified by:EC IPP Rev:B 14.04.30 as per dwg rev.b DD verified by:JLM IPP REV:C 17.11.17 AS PER DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	8 pcs	12/10/18	12/10/18	0.00	1.23	Waterjet - Flow		SC 18/11/26
110	QC	8 pcs	12/10/18	12/10/18	0.00	0.00	QC2 Waterjet-2		SC 18/11/26
120	QC	8 pcs	12/10/18	12/10/18	0.00	0.00	QC8-3		NOV 29 2018 68
130	Large Fab	8 pcs	12/10/18	12/10/18	0.00	13.56	Large Fab 1		13L 9-89
135	Autoweld 1	8 pcs	12/10/18	12/10/18	0.00	0.80	Automated welding		13L
140	QC	8 pcs	12/10/18	12/10/18	0.00	0.00	QC9		EL
150	QC	8 pcs	12/10/18	12/10/18	0.00	0.00	QC5		EL
180	Packaging	8 pcs	12/10/18	12/10/18	0.00	0.00	Packaging3		576/0218
190	QC21-SA	8 Ea	12/10/18	12/10/18	0.00	0.00	QC21		FEB 06 2019

Part Op 100 - 1-Cut as per Dwg D3859-1 Dwg Rev: C Prog Rev: C 2-Deburr if necessary
Descriptions: 130 - 1-Weld D4379-5 cups as per dwg D3859 A/R 316L stainless steel rod *****use DT9462 for welding***** 2- WELD
HARDCOAT TO BAR 2059B HARDCOAT BATCH: 3- POLISH WELS SURFACE AREA AS PER DWG
NOTE2
135 - AUTO WELD HARDFACING 8259 BATCH: 138901

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	6.8000 sf (.85 ea)	100-Waterjet - Flow - 1	5123205
D4379-5	Wearplate Cup	48 Ea (6 ea)	130-Large Fab	20-5136209, 146059

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	7	157	0
130-Large Fab	D4379-5	48	122	0

Part Specifications

Specifications could not be found.

7-930 - 25
8-11:30 - 35
6hrs

Plex 11/22/18 11:10 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Thermof... ☐		AGAINST DEPARTMENT/PROCESS Cross tube ☐ Small Fab ☐ Water Jet ☐ Prod. Eng. Coord ☐ Engineering ☐ Quality ☐ Other ☐	
Date : _____		Step #: _____		Container No: S131589 Part: D3859 - 041 Job No: 186885 Serial No/Batch: S131589 Inspector: C Exp Date: _____ Instructions: Various STC's Date: 11/26/18	
Description Work Order Deviation					

Root Cause			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐
OTHER : _____			

